

Date: Friday, 3/9/2007 10:30:43 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : X-TUBE 412 **POSITIVE RECALL**
 Job Number : 31141
 Estimate Number : 12727
 P.O. Number :
 This Issue : 3/9/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D412664245
 First Issue : / / Type : LANDING GEAR Drawing Number : D412-664-245 *YR AL 07.03.09*
 Previous Run : 31140 Project Number : N/A
 Material :
 Due Date : 4/6/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : *07.03.09*
 Comment : Est Rev: A New Issue 07-02-14 JLM

Additional Product

Job Number:



Sup

Seq. #:

Machine Or Operation:

Description:

1.0

D6009129

Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6009-129-Crosstube *29668*

Check OD = 3.500"; ID = 2.250"

BG 07.03.12

(1)

2.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD412-664-205

CHG001

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Dwg D412-664-245

BG / D.F 07/03/13

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BG / D.F 07/03/13

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Sn 07/03/15 (x1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: X-TUBE 412

Job Number: 31141

Part Number: D412664245

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

DP 7-3-22

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JA 03-22

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-3-22

9.0

QC3/5

INSPECT WORK/WING WALK



Comment: Inspect work & Chemical conversion Coat

JA 03-22

10.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

PRD
EL 7-8-20

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

12.0

D36061

CUFF



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CUFF

Batch: _____

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Rivet holes as per Dwg D412-664-245



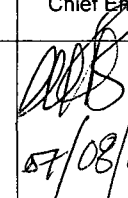
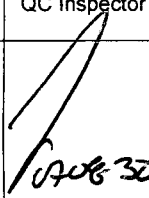
2-Drill pilot holes in tube as per Dwg D412-664-245

3-Ream hole to finish size in tube as per Dwg D412-664-245

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-08-30	100	Tube broke in the bender. No apparent voids in the material.	 07/08/30	Scrap & destroy	EL 07-08-30	 07-08-30	 07/08/31	 07-08-30

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE 412

Job Number: 31141

Part Number: D412664245

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-245

14.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube & Cuffs as per QSI 005 4.1

15.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0 OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: _____ LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

18.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

19.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

20.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet Cuffs as per Dwg D412-6647-245. with Sika flex in Between tube & Cuff

A/R SIKAFLEX -241/-291 BATCH: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Friday, 3/9/2007 10:30:43 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE 412

Job Number: 31141

Part Number: D412664245

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

CR3212406

CHERRY RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
CHERRY RIVET
Batch: _____

22.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

23.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint
Wrap in plastic bag to protect from scratches

24.0

D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Chafing Shield
Batch: _____

25.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0536 sf(s)/Unit Total : 0.0536 sf(s)
Rubber Cushion
Cut to .630" X 5.8" X 2PCS
Batch: _____

26.0

D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part number Description Batch
1 D2896-1 Support _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE 412

Job Number: 31141

Part Number: D412664245

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D2856600

Abrasion Strip



Comment: Qty.: 0.9450 f(s)/Unit Total : 0.9450 f(s)

Abrasion Strip

2 X D2856-600-1009

Batch: _____

28.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp _____

29.0

MS2192032

clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch: _____

30.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-245

Install Chaffing Sheilds

Instal support with magnobond 6398 per dwg D412-664-245,
cure for 12hrs before packaging.

Time & date of application: _____

Batch: _____

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-205

POSITIVE RECALL

EFFECTIVE 07.13.05 AUTH UP

RELEASED _____ DATE _____

Form: process

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 3/9/2007 10:30:44 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE 412

Job Number: 31141

Part Number: D412664245

Job Number:



Seq. #:

Machine Or Operation:

Description :

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date

Time & date of packaging: _____

Location: _____

PPP Rev: _____

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 070904

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 90	DRAWN BY 90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D412-664-245	REV. B SHEET 1 OF 3
DATE 07.03.01		TITLE CROSSTUBE ASS'Y (412 LOW-N AFT) NTS	
A	06.12.01	NEW ISSUE	
B	07.03.01	CHG CUFF AREA, CHG RUBBER CUSHION	

PRELIMINARY ISSUE

PARTS LIST:

Qty	Part Number	Description
X	D412-664-245	CROSSTUBE ASSEMBLY (412 LOW-NARROW AFT)
1	D6009-129	CROSSTUBE
2	D2856-600-1009	ABRASION STRIP
1	D2896-1	SUPPORT
2	D3189-1	CHAFING SHIELD
2	D3595-063-580	RUBBER CUSHION
2	D3606-1	CUFF
44	CR3212-4-06	RIVET (OR M7885/3-4-06)
4	MS21920-28	CLAMP
2	MS21920-32	CLAMP
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

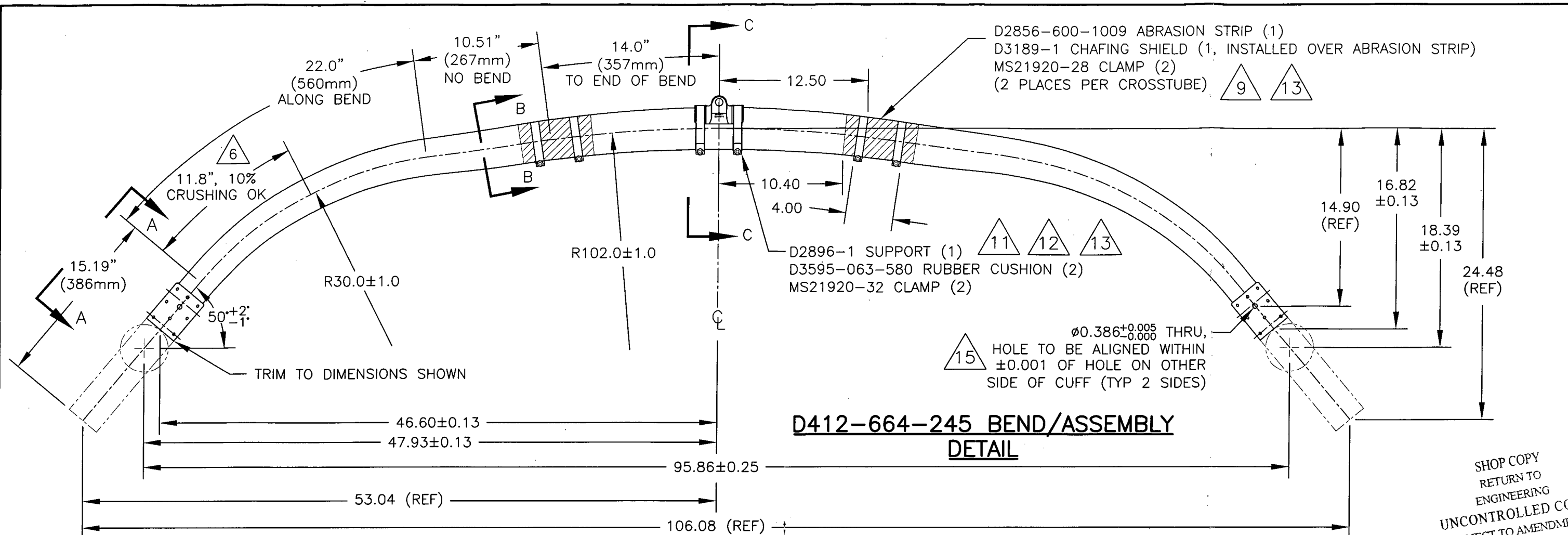
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 123.59±0.020 (BEFORE BENDING/TRIMMING)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PAINT INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-32 CLAMPS WITH D3595-063-580 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB.
- 14) INSTALL D3606-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT. WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE.
- 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 31141

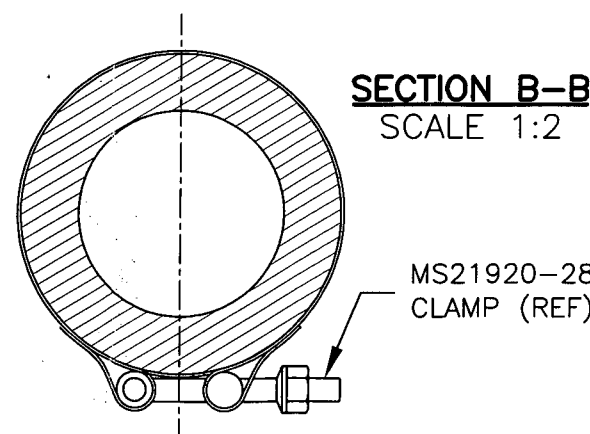
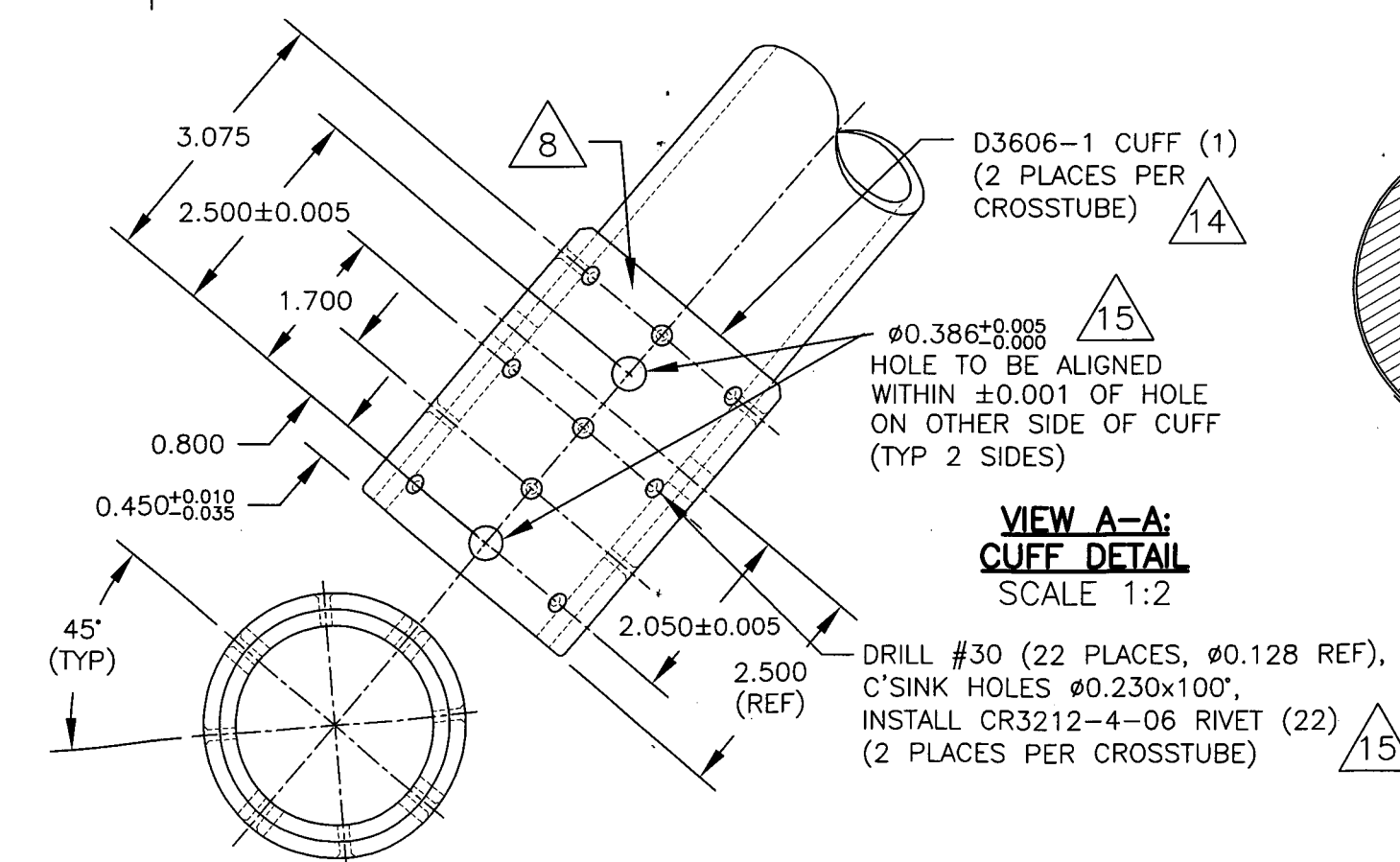
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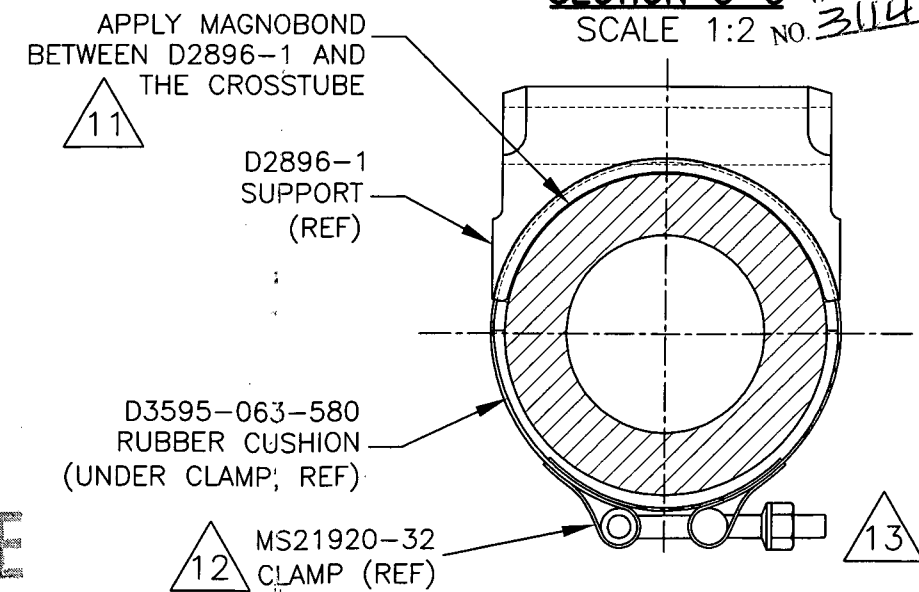


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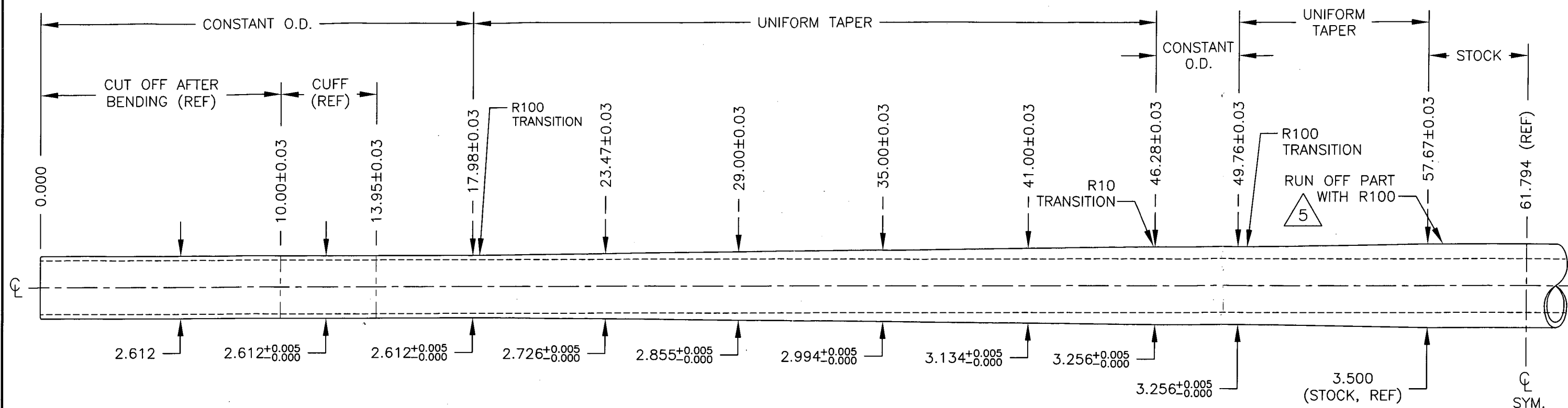
SECTION C-C
SCALE 1:2 NO. 31141



PRELIMINARY ISSUE



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		DATE	07.03.01			D412-664-245	SHEET 2 OF 3
						TITLE	SCALE
						CROSSTUBE (412 LOW-NARROW AFT)	1:8



D412-664-245 MACHINING DETAIL

PRELIMINARY ISSUE

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NO. 31141

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DATE 07.03.01		TITLE CROSSTUBE (412 LOW-NARROW AFT)		SCALE 1:4	

DART AEROSPACE LTD		Work Order:	
Description: X-Tube		Part Number:	0412-664-2-5
Inspection Dwg: 0412-664-2-5 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

SIDE "A"

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	2.612	+0.005 -0.000	2.616	✓			
B	2.726	"	2.730	✓			
C	2.855	"	2.859	✓			
D	2.994	"	2.998	✓			
E	3.134	"	3.138	✓			
F	3.256	"	3.260	✓			
G	3.500	stock REF	3.490				
H	123.588	±0.02	123.588	✓			
I							
J	2.612	+0.005 -0.000	2.618	✓			
K	2.726	"	2.726	✓			
L	2.855	"	2.856	✓			
M	2.994	"	2.995	✓			
N	3.134	"	2.135	✓			
O	3.256	"	2.256	✓			
P	3.500	"	3.500	✓			
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: BG/LP	Audited by: En	Prototype Approval:	N/A
Date: 07/03/15	Date: 07/03/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

